

Patent claims

- 5 1. Method for producing a data carrier in which at least two substrates are adhered to one another by applying to a first substrate (6) an adhesive film (25) that is adhesive on two sides; aligning a second substrate (6) with respect to said first substrate (6); and joining said substrates (6, 10) to one another, characterized in that said adhesive film (25) is pressed onto said substrate (6) using a rotating pressure roller (33) while said substrate (6) and said pressure roller (33) are moved relative to one another.
- 10 2. Method in accordance with claim 1, characterized in that said adhesive film (25) is withdrawn from a carrier film (26) during or after application to said first substrate (6).
- 15 3. Method in accordance with claim 1 or 2, characterized in that a protective film (24) is withdrawn from said adhesive film (25) prior to its application to said first substrate (6).
- 20 4. Method in accordance with any of the preceding claims, characterized in that the shape and size of said adhesive film (25) corresponds to the surfaces of said substrates (6, 10) to be adhered.
5. Method in accordance with any of the preceding claims, characterized in that sections (27) of said adhesive film (25) that correspond to the shape and size of said substrates (6, 10) are punched onto said carrier film (26).

6. Method in accordance with any of the preceding claims, characterized in that said adhesive film (25) is applied centered on the surface of said substrate (6) to be adhered.
- 5 7. Method in accordance with any of the preceding claims, characterized in that said adhesive film (25) and said substrate (6) are aligned with one another prior to application.
8. Method in accordance with any of the preceding claims, characterized in that the pressure of said pressure roller (33) is controlled.
- 10 9. Method in accordance with any of the preceding claims, characterized in that prior to pressing by said pressure roller (33) said adhesive film (25) is held at a pre-specified angle relative to the surface of said substrate (6).
- 15 10. Method in accordance with any of the preceding claims, characterized in that said substrate (6) is moved past said pressure roller (33) linearly.
11. Method in accordance with claim 12, characterized in that said pressure roller (33) is rotated synchronously to the movement of said substrate (6).
- 20 12. Method in accordance with any of the preceding claims, characterized in that said substrates (6, 10) are placed on a centering and holding device (60) for aligning them.

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10), characterized in that said laminating station (7) has a rotatable pressure roller (33) and a device (47) for moving said substrate (6) and/or said pressure roller relative to one another.

5 21. Apparatus in accordance with claim 20, characterized in that the shape and size of said adhesive film (25) correspond to the surfaces of said substrates (6, 10) to be adhered.

10 22. Apparatus in accordance with either of claims 20 or 21, characterized in that sections (27) of said adhesive film (25) that correspond to the shape and size of said surfaces of the substrates (6, 10) to be adhered are punched onto a carrier film (26).

15 23. Apparatus in accordance with any of claims 20 to 22, characterized in that said laminating station (7) has an aligning unit for aligning said adhesive film (25) with the surface of said substrate (6) to be adhered.

24. Apparatus in accordance with claim 23, characterized in that said device has at least one linear movement unit (47) for said substrate (6).

20 25. Apparatus in accordance with any of claims 20 through 24, characterized by a centering and holding device (60) that in a first position holds said substrates (6, 10) spaced from one another and in a second position enables centered joining of said substrates (6, 10).

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